

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2016-134 Date Opened: 13 Oct 16 Title: Fabrication

Aircraft OEM: All Aircraft Model: All Product Type: Handle Provisions Product Model: Bushing Quantity: 346/20

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	N/A
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	N/A
Completed Certification	N/A
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	N/A
Dual Inspections Initialled	N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
84272	1	Handle Bushing	JC
100621	0	Hoop	JC

Traveller

		Initial or N/A
346 x 84272-01	Bushing @0.5 long	DB
20 x 100621-03	Bushing @ 0.75 long	DB

Component Completion

	As Instructed
Quantity Complete on This Work Order	346/20
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	JC
In Process (Yellow) Tag Completed	JC
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by:

Print: D. Bartfai

Sign: [Signature]

SCA: AD07

Date: 13-Oct-16

ICC / Dual Inspection preformed by:

Print: N/A

Sign: [Signature]

SCA:

Date:

Work Order closed by:

Print: J. Clarke

Sign: [Signature]

SCA: AD02

Date: 08-May-17

Approved Manufacturing Facility 73-04

Form 2017.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Handle Bushing No. of pieces: 346

Manufacturer: Aero Design Ltd

Part No.: 84272-01 Serial/Batch No.: 16070

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-134

Remaining Tasks to be Performed: Deburr

Signature: [Signature]

Date: Oct 13th/2016 Lic. No. / SCA AD-07

In Process



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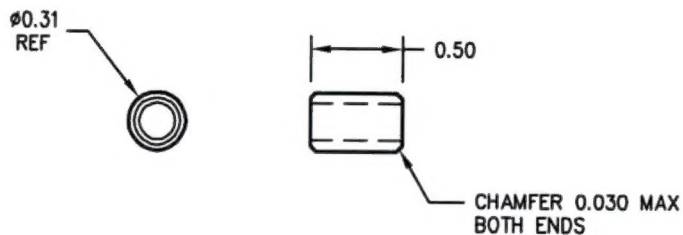
Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK, ADD ALTERNATE MATERIAL	BJC	MAR 13/14




01 BUSHING

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

	01	(ALTERNATE MATERIAL)	304 STAINLESS STEEL	ASTM A269	0.313 X 0.058 RND. TUBE	
	84272-01	01 BUSHING	4130 STEEL, COND. N	MIL-T-6736	0.313 X 0.058 RND. TUBE	
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

QTY LIST OF MATERIALS

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1						
				HELICOPTER CARGO BASKET BUSHING			
				SCALE 1 : 1 SHEET 1 OF 1	DWG. SIZE A4	DWG. NO. 84272	REV. 1

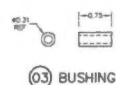
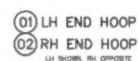
Aero Design

Parts Distribution Sheet

Description: Handle Bushings

WO# 2016-134

[illegible]

[illegible]

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2016-136 Date Opened: 13 October 2016 Title: Fabrication

Aircraft OEM: Bell Aircraft Model: 212 Product Type: Cargo Basket Product Model: Mega Quantity: 3 extended lid

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	DB
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	DB
Parts Distribution Sheet	DB
Sub Component Tags	N/A
Completed Certification (Original)	N/A
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100612	0	Lid	DB
100623	0	Lid End Hoop	DB
100624	0	Lid Hoop	DB

Traveller

Initial or N/A

Component Completion

	As Instructed
Quantity Complete on This Work Order	3
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	JC
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Note:

Work performed by:

Print: D. Bartfai

Sign: [Signature]

SCA: AD07

Date: 19-Jan-17

ICC / Dual Inspection performed by:

Print: J. Rekve

Sign: [Signature]

SCA: AD01

Date: 19-Jan-17

Work Order closed by:

Print: J. Clarke

Sign: [Signature]

SCA: AD02

Date: 09-May-17

Approved Manufacturing Facility 73-04

Form 2000.03

Rev. Original 23 Sep 2014

212 MEGA LID HOOPS 3/4" 4130 (HIGH LID) (ENTER HOOPS)

MODEL	Requirements	
	<ul style="list-style-type: none"> - Cut Review LOEP to ensure most current technical specifications - Cut 3/4" 4130 to 44 7/8" 90° both ends - Deburr using appropriate methods - remove writing using a scotchbright pad and solvent. - measuring from one end mark 18 1/8" and 33 1/16" in pencil - set 3/4" bender up in bend station - set lower stop to 99° - with short end in bender line up (18 1/8" mark) pencil mark with marks on bender. (picture) - place 1/2" x 3/4" block between back of bender and tube to be bent. - pull quickly and evenly. - contact stop firmly - remove tube from bender and check for height and square. - place unbent side in bender keeping previously bent portion pointing towards you. - line up 33 1/16" in bender - place block 1/2" x 3/4" between back of bender and tube to be bent. (picture) - pull quickly and evenly - contact stop firmly - check Remove from bender 	<p><u>Caution:</u></p> <ul style="list-style-type: none"> - make one complete hoop first. - Lock lower stop down tightly - check hoops for twist - be sure mark on tube and mark on bender remain together until tube starts to to bend - width 25 3/8" - height 15.750" - height 5.750"

- check for square, width, height.
- remove material as needed from short side.

212 MEGA LID HOOPS 3/4" 4130 (HIGH LID) ENDS

MODEL Requirement

Review LOP to ensure most current technical specifications

- Cut 3/4" 4130 to 4511/6 90° ball ends

- Deburr ends using appropriate methods

- Remove welding using a scotch bright pad and

alight solvent.

- measuring from one end mark the tube with

pencil at 18 7/8 and 33 13/16.

- Set 3/4" ~~3~~ bender up in bend station

- set lower stop to 90°

- with short (57/8) end in bender (left) line up punch marks with bend mark on tube.

- Place 1/2" x 3/4" aluminum block between back

of bender and tube to be bent.

- pull quickly and evenly

- contact stop firmly.

- Remove tube from bender and check

for height and square

- Place in bent end into bender until the

33 13/16 mark is lined up with the punch

marks on bender. keep bent pipe toward yourself.

- place 1/2" x 3/4" aluminum block between back

of bender and tube to be bent.

- pull quickly and evenly.

- contact stop firmly.

- Check for square height and width.

- Remove material as needed from short side of

hoop.

- short side should have 45° angle cut

cautions

- Make one hoop complete first adjust if needed.

- Lock lower stop down

thightly

- check hoops for twist.

- be sure mark on tube

and mark on bender stay

together until tube starts

to bend.

- width 25 3/8

- Long height 16.50

- short height 6.50

- both end hoops should have opposite 45° angles on low side. to receive rim tube. (Picture)
- Both ends should have parallel 45° cut in fall ends

CARGO BASKET LID FABRICATION – Bell Medium Mega

General

These instructions apply to Bell Medium Mega cargo basket lid assembly. Refer to the following drawings, at the current revision, for dimensions and details:

Bell Medium – left or right

100611, Revision 0 – Standard Lid

100613, Revision 0 – Extended Lid

Work Order: 2016-136

Qty 3

Date Open: 3 Oct 2016

Complete
(initial or SCA #)

#1	#2	#3	#4	#5
AD	AD	AD		
73-04	73-04	73-04		
01	01	01		

1. Frame assembly – Lid

a. General

- Vent holes shall be #30 (0.129), located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
- Pull required hoops from stock.
 - If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - Ensure vent holes are located to vent walkway tubes.
- Cut $\frac{1}{2}$ " x 0.035 material for walkway sections to fit jig.
- Cut $\frac{3}{4}$ " x 0.035 material for side rim to fit from inboard rim to outboard rim at both ends.
 - Refer to drawing for position.
 - Drill hole for lid prop bushing as indicated on drawing.
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- Drill vent holes into rim to vent hoops into rim and walkway tubes into hoops.

AD	AD	AD		
73-04	73-04	73-04		
05	05	05		

2. Weld frame assembly.

- Record welding rod PO on attached material list.
- Jigs must remain in place for as long as practical during welding.

AD	AD	AD		
73-04	73-04	73-04		
05	05	05		

3. Inspection

- Frame assembly for complete welds.

AD	AD	AD		
73-04	73-04	73-04		
01	01	01		

4. Mesh assembly.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Bend body mesh –

CARGO BASKET LID FABRICATION – Bell Medium Mega

Complete
(initial or SCA #)
#1 #2 #3 #4 #5

- Standard Lid – Bend is made at ?? (figure).
- Extended lid – Bends are made at ?? and ?? (figure).
- Align 3" tube to required position and clamp tube in place.
- Bend mesh by hand tightly over tube along length of tube.
- Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
- Bend mesh by hand tightly over tube along length of tube.

5. Weld mesh to frame assembly per drawing.

a. General welding requirements:

- Every intersection on all edges.
- First 5 intersections along hoops, then every second intersection.
- Insert lid in fixture prior to welding mesh.

b. Record welding rod PO on attached material list.

AD
73-04
05

AD
73-04
05

AD
73-04
05

6. Weld lid components.

a. Handle brackets, locate in accordance with drawing.

- $\frac{1}{4}$ " outside of last cross member on both ends.

ii. Record handle bracket WO and welding rod PO on attached material list.

b. Lid prop bushings, both ends.

- Record lip prop bushing WO and welding rod PO on attached material list.

c. Placard bracket.

- Locate on cross member to set bracket in centre bay of lid.
- Record placard bracket WO and welding rod PO on attached material list.

AD
73-04
01

AD
73-04
01

AD
73-04
01

7. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid by clamping the lid to welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Remove surface rust with scotch-brite pad.

AD
73-04
01

AD
73-04
01

AD
73-04
01

8. Final Inspection

To be completed by a different person than the previous steps.

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

AD
73-04
01

AD
73-04
01

AD
73-04
02

9. Powder Coating

- Parts are to be powder coated in accordance with commercial practices.
- Inspect powder coating on receiving.
- Tag lid assembly and place into stock in preparation for assembly.

Work Order: 2016-136Date Opened: Oct 2016Material Tracking Sheet
Bell 205/212 Mega Extended Lid Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>23</u>	<u>Draw</u>	100613-01	Extended Lid Assembly (High)		
Step 1				<i>Frame Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (108.75")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15037</u>
	. 2		--	3/4" Tube - Side Rim (26")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15037</u>
	. 1		100625-01	LH Lid End Hoop	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15037</u>
	. 1		100625-01	RH Lid End Hoop	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15037</u>
	. 5		100626-01	Lid Hoop	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>15037</u>
	. 12		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>15072</u>
Step 2				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14005</u>
Step 3				<i>Inspection - Frame</i>	None	
Step 4				<i>Mesh Assembly</i>		
	. 1		--	Mesh (lid - 108" x 42")	3/4-16F Expanded Mild Steel sheet	<u>15037</u>
Step 5				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	<u>15090</u>
Step 6				<i>Weld Lid Components</i>		
Step 6.a.	. 1	84263	84263-01	Lid Handle Bracket Assembly		<u>2016-54</u>
	. . 2		84263-02	Handle Bracket Assembly		
	. A/R		--	Welding Rod	ER308L TIG Rod	<u>14028</u>
Step 6.b.	. 2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	<u>2015-84</u>
	. A/R		--	Welding Rod	ER308L TIG Rod	<u>14028</u>
Step 6.c.	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	<u>15061</u>
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>14005</u>

Work Order: 2016-136

Date Opened: Oct 2016

Material Tracking Sheet
Bell 205/212 Mega Extended Lid Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 7				Clean Up		
Step 8				Inspection - Final Assembly		
Step 9				Powder Coating		16073 / 16081 / 17012

Work Order: 2016-136

Material Tracking Sheet

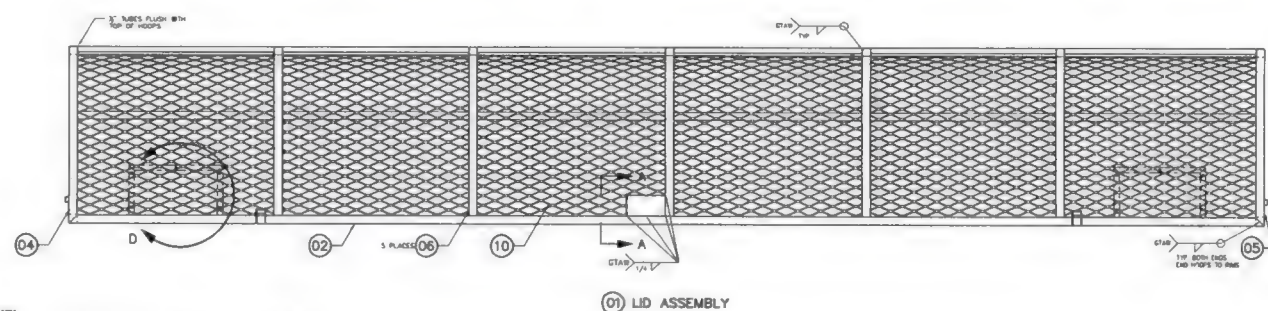
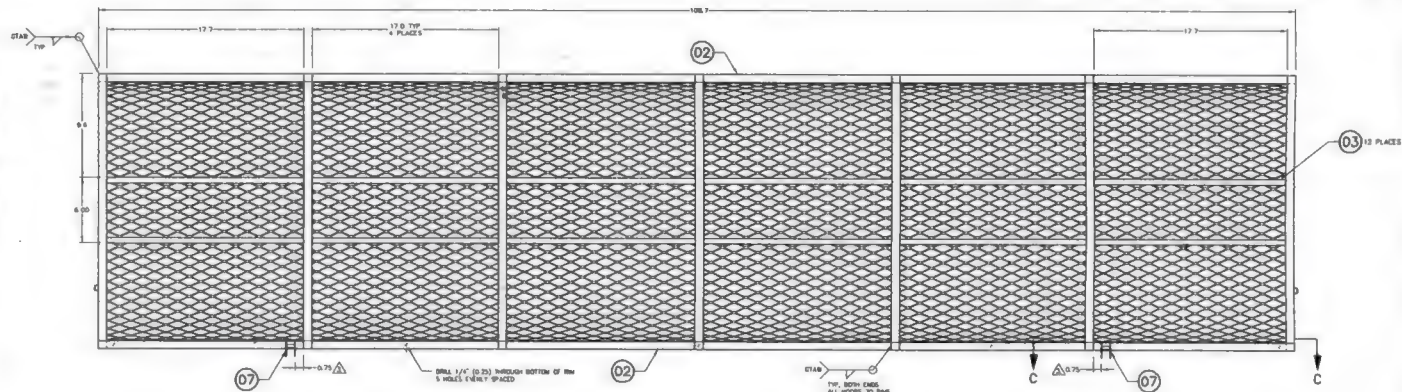
1 of 1

Date Opened: Oct 2016

Bell 205/212

Mega Lid Hoops

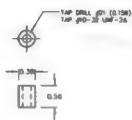
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
				<i>Standard Lid</i>		
	N/A		100623-01	LH End Hoop - Standard Lid	4130 Steel, 3/4" x 0.035 Sqr. Tube	
	N/A		100623-02	RH End Hoop - Standard Lid	4130 Steel, 3/4" x 0.035 Sqr. Tube	
	N/A		100624-01	Hoop - Standard Lid	4130 Steel, 3/4" x 0.035 Sqr. Tube	
				<i>Extended Lid</i>		
	3		100625-01	LH End Hoop - Extended Lid	4130 Steel, 3/4" x 0.035 Sqr. Tube	15037
	3		100625-02	RH End Hoop - Extended Lid	4130 Steel, 3/4" x 0.035 Sqr. Tube	15037
	15		100626-01	Hoop - Extended Lid	4130 Steel, 3/4" x 0.035 Sqr. Tube	15037



① LID ASSEMBLY

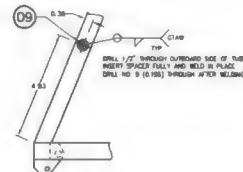
1 REMOVE ALL BURRS AND BREAK SHARP EDGES

- 4) WELDING OF 430 STEEL TO BE COMPLETED BY 12AM WEEK 10. AMB 3980C
430 AND 430B STEEL WELDING ROOF SHALL CONFORM TO ENDS-2 OF EQUIVALENT
STAINLESS AND 430 STEEL WELDING ROOF SHALL CONFORM TO DESIGN OR EQUIVALENT
- ⚠ METALL ITEM 5 (OLD HANDS) PROVIDING ASSEMBLY IN ACCORDANCE WITH AERO DESIGN 101
DRAWING 848783, LOCATED AS SHOWN:
- ⚠ AMB 430 (84783) VIOLES IN LONG TERM MEMBERS AT ROOF LOCATIONS TO NOT WELD GASKETS
WHEN ASSEMBLY IS COMPLETE. ALL EXPOSED NUT HOLES WITH BUSHETTE WELD
- 5) FINISH THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY
THOROUGHLY DEGREASE, ALCOHOL RINSE AND TO PURCHASE PART COVER PLATE (ITEM 13)
ALTERNATE, THOROUGHLY DEGREASE AND POWDER COAT COVER PLATE (ITEM 13)



⑫ THREADED BUSHING

SCHE 1.1




SECTION A-A

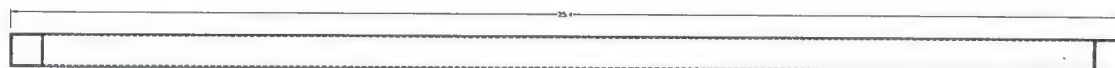
SCALE 1/2
TYPICAL, BOTH ENDS

SCALE 1 2

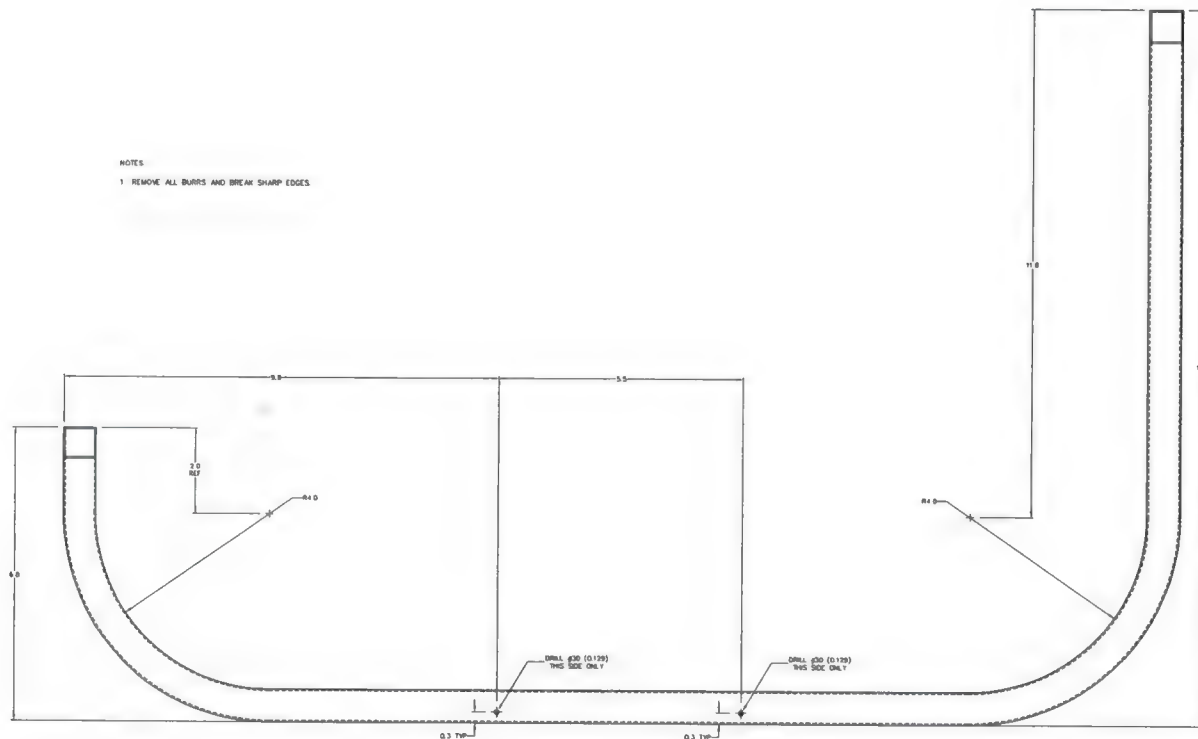
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APPROVALS	DATE	 AERO DESIGN LTD. 2000A HALL AVENUE POWELL RIVER BC, CANADA, H8A 6G2 TEL: (604)-696-2070 www.aerodesign.com
DRAWN: JEFF CLARKE DATE: 26 NOV 2004 CHECKED: JASON REVE DATE: 27 NOV 2004		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:		BILL 200, 212, 214, 412, SERIES QUICK RELEASE MECHA CARTRIDGE EXTENDED LID ASSEMBLY
DECIMALS FRACTIONS ANGLES HOLE DIA TAP DIA HOLE DIA HOLE DIA	1/16 1/32 1/2 1/2 1/2 1/2	SCALE: 1" = 1" (SEE DIMS) SHEET 1 OF 1 A1 100613 0

REVISIONS		DESCRIPTION OF CHANGE	REVISED BY	DATE
01		INITIAL ISSUE		




NOTES
1 REMOVE ALL BURRS AND BREAK SHARP EDGES

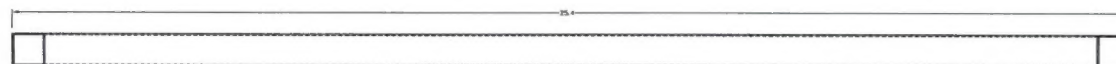


- 01 LH EXTENDED LID END HOOP
02 RH EXTENDED LID END HOOP
LH SHOWS RH OPPOSITE

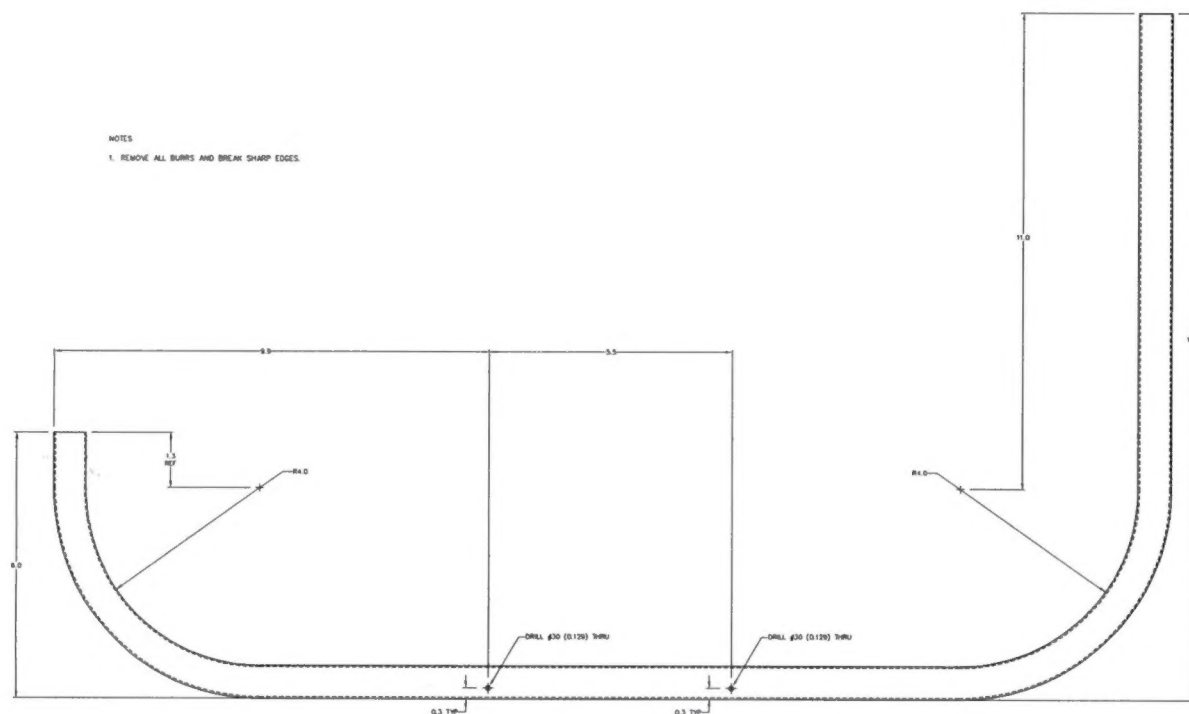
100625-01	LH EXTENDED LID END HOOP	14.00 INCH LONG H	14.00 INCH W	0.75 X 0.035 SQD TUBE	
100625-02	RH EXTENDED LID END HOOP	14.00 INCH LONG H	14.00 INCH W	0.75 X 0.035 SQD TUBE	
QTY	PART NO	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	100625-01	LH EXTENDED LID END HOOP	ALUMINUM	6061-T6	0.75 X 0.035 SQD TUBE
1	100625-02	RH EXTENDED LID END HOOP	ALUMINUM	6061-T6	0.75 X 0.035 SQD TUBE

APPROVALS		DATE		AERO DESIGN LTD. 205, 212, 214, 412 SERIES QUICK RELEASE MEGA CARGO BASKET EXTENDED LID END HOOP
DESIGNED:	JEFF CLARKE	27 NOV 2014		
CHECKED:	JASON HEANE	27 NOV 2014		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:				
DECIMALS	±0.010	FRACTIONS	±1/32"	
HOLES	±0.010			
HOLES	±0.010			
SCALE	1:1	SHEET NO	REV	
SHEET 1 OF 1		A0 100625 0		

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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INTERNAL ISSUE		



NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.



01 EXTENDED LID HOOP

100626-01 01 EXTENDED LID HOOP			4130 STEEL 2006 H	WEL-C-8758	15.75 X 0.035 SQD TUBE	
QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			
APPROVALS			DATE		 AERO DESIGN LTD. 8888A SALLADIPPA ROAD POWELL RIVER, BC, CANADA V8A 0G3 TEL: 250-466-0899 FAX: 250-466-0898 www.aerodesign.ca	
DRAWN: JEFF CLARKE			27 NOV 2014			
CHECKED: JASON REAVE			27 NOV 2014			
UNLESS OTHERWISE SPECIFIED:						BELL 206, 212, 214, 412 SERIES QUICK RELEASE MEGA CARGO BASKET EXTENDED LID HOOP
DIMENSIONS ARE IN INCHES						
TOLERANCES ON:						
DECIMALS						
X.XXX ±0.010						
X.XX ±0.03						
X.X ±0.1						
ANGLES						
31/2°						
SCALE 1 : 1			SHEET 1 OF 1		REV	
			A0 100626		0	



ARMOR ALLOYS

Edmonton, AB T. (780) 463-2207

Calgary, AB T. (403) 265-3190

Vancouver, BC T. (604) 942-2424

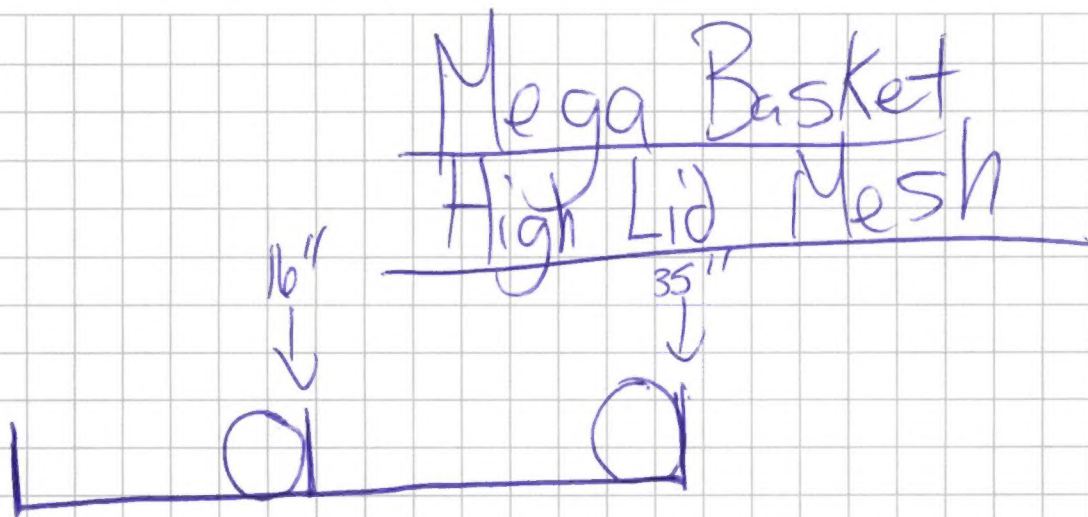
Service@ArmorAlloys.com

Calgary@ArmorAlloys.com

Vancouver@ArmorAlloys.com

24 / 7 After-Hour Service Available

Registered to ISO 9001





Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: EXT. LID (MEGA) No. of pieces: 1

Manufacturer: AERO DESIGN LTD.

Part No.: 100613-01 Serial/Batch No.: ASN

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-136

Remaining Tasks to be Performed: INSPECT POWDER COAT
✓ ✓

Signature: JH CCH

Date: 28 OCT 2016 Lic. No. / SCA A002

In Process



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Remarks

In Process
